

Work Order ID 73831



Page 1

Friday, September 16, 2011 11:43:35 AM

Item ID: D3873-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 9/16/2011 Start Qty: 400.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 400.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3873

B

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

1-TURN AS PER FOLIO FA806 & DWG D3873,
FOLIO REV: 1A
DWG REV: _____

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

Handwritten notes:
11/10/05 400 *✓*
11/10/05 400 *✓*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, September 16, 2011 11:43:35 AM

Page 2

Accept

[illegible]**Setup Start**

Stop

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. The second step is to define the objectives and goals of the project. This involves determining what you want to achieve and how you will measure success.

3. The third step is to develop a plan of action. This involves identifying the steps that need to be taken to achieve the objectives and goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and monitoring progress.

5. The fifth step is to evaluate the results. This involves assessing the outcomes of the project and determining whether the objectives and goals have been achieved.

6. The sixth step is to report on the results. This involves communicating the findings of the project to the relevant stakeholders.

7. The seventh step is to reflect on the process. This involves thinking about what worked well and what could be improved for future projects.

8. The eighth step is to share the results. This involves making the findings of the project available to others who may be interested.

9. The ninth step is to celebrate success. This involves acknowledging the achievements of the team and celebrating the successful completion of the project.

10. The tenth step is to learn from the experience. This involves reflecting on the project and identifying lessons learned that can be applied to future projects.

Cust Item ID:

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Customer:

Reference:

Run Start

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

**Insp.
Stamp**

0.00

[illegible]

QC

Memo

0.00

Quality Control

B.A 11/10/06

400

①

0.00

[illegible]

Packaging

Packaging

Memo

0.00

5011-10-11

0.00

[illegible]

OC

Memo

0.00

Quality Control

n/w/n

ME 11-10-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 16, 2011 11:43:32 AM

Page 1

Work Order ID: 73831

Parent Item: D3873-1

Parent Item Name: Bushing



Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 400.00

Required Qty: 400.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303R0.625

Purchased

No

100

f

15.2000

0.06

25.26316



303 Round Bar 0.625"



[Handwritten signature]

11/10/05

Location

Loc Qty

Loc Code

MAT028

15.2

110167

3.2

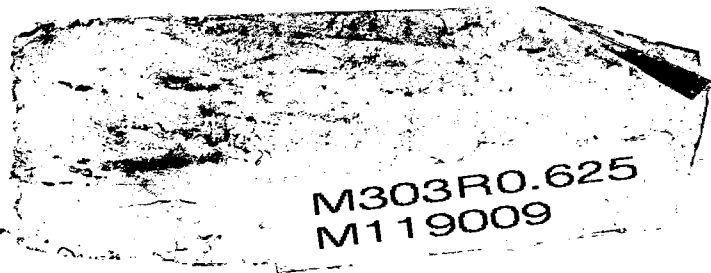
118400

12

✓ M119009

~~23.3331~~

24'



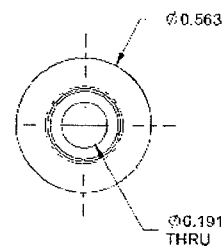
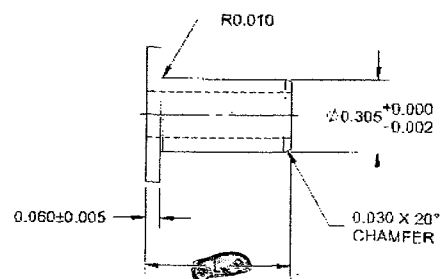
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3873-X BUSHING



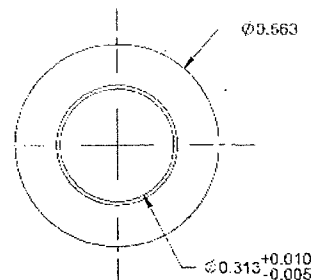
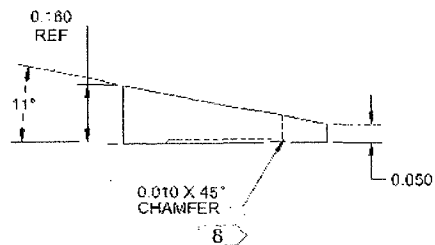
DART P/N	WEIGHT (lbs)
D3873-1	0.600
D3873-3	0.120
D3873-6	0.270

RELEASED
2011-09-12

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

C	ADD D3873-3/-5/-7 (ZIN BG-1 & B5-2)	RF	11.06.14
B	Ø0.563 WAS Ø0.53 (CS 1, TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	EE	D3873	SHEET 1 OF 2
APPROVED	142	TITLE	SCALE
DE APPR.	142	BUSHING	NTS
DATE	11.06.14	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS TO BE RELEASED EXCEPT WHERE SHOWN OTHERWISE. IT IS TO BE RELEASED EXCEPT WHERE SHOWN OTHERWISE. IT IS TO BE RELEASED EXCEPT WHERE SHOWN OTHERWISE.	



C **D3873-7 SPACER**



NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3873	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BUSHING	NTS
DATE	11.06.14	<small> COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS NOT BE RELEASED OR DISCLOSED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC. </small>	

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2011-09-12